

January-14-14 10:58:32 AM

Page 1

Date:

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1

1990

2

4

2000

100%

1

-15-

10

Work Order ID 111369

January-14-14 10:58:32 AM

111369

Page 3

Item ID: D2893-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Support

Stop ***NS2***

Start Date: 1/14/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 2/25/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 14-01-29

MLJ 14-01-29

Picklist Print

January-14-14 10:58:36 AM

Page 1

Work Order ID: 111369

111369

Parent Item: D2893-1

D2893-1

Parent Item Name: Support

Start Date: 1/14/14

Required Date: 2/25/14

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C02.11.26Reformat; Added P/OKJ

IPP D 06.04.19 removed alodine EC

IPP Rev:E Added priming as per Rev B 07-04-30 JLM

IPP F 08.03.19 Re-format EC verified by: DD

IPP Rev:G 08-05-15 add QC14 DD verified by:EC

IPP Rev:H

11.08.04 as per dwg rev.C DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| DŠK078 | | Manufactured | No | | | 100 | Each | 14.0000 | 0.5 | 11 | | | |

DSK078

D2893-1 Turning Detail

**

D.A 13/01/21

Location

Loc Qty

Loc Code

MAT060

14

108383

4

→ 109148

10

10.0

| | | | |
|------------------------------------|--|---------------------|--------------------|
| DART AEROSPACE LTD | | Work Order: | 111369 |
| Description: Ø2.750 Support | | Part Number: | D2893-1 |
| Inspection Dwg: D2893 | | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| | | | | Record Actual Dimensions | | | | |
|----------------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| HAAS Section | | | | | | | | |
| AA | 2.985 | 3.005 | | 2.995 | 2.995 | 2.995 | 2.995 | 2.995 |
| AB | 0.440 | 0.460 | | .440 | .440 | .440 | .440 | .440 |
| AC | 0.125 | 0.160 | | .128 | .125 | .128 | .128 | .128 |
| AD | 0.040 | 0.060 | | .050 | .050 | .050 | .050 | .050 |
| AE | 0.188 | 0.193 | | .189 | .189 | .189 | .189 | .189 |
| AF | 0.125 | 0.160 | | .140 | .140 | .140 | .140 | .140 |
| AG | 0.140 | 0.160 | | .148 | .148 | .149 | .151 | .149 |
| AH | 1.360 | 1.400 | | 1.371 | 1.373 | 1.370 | 1.373 | 1.370 |
| AI | 0.040 | 0.060 | | .0538 | .051 | .0534 | .052 | .0532 |
| AJ | 1.190 | 1.230 | | 1.214 | 1.215 | 1.214 | 1.214 | 1.212 |
| AK | 0.010 | 0.020 | | .010 | .010 | .010 | .010 | .010 |
| AL | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AM | 0.240 | 0.260 | | .250 | .250 | .250 | .250 | .250 |
| AN | 2.518 | 2.538 | | 2.528 | 2.518 | 2.528 | 2.518 | 2.528 |
| AO | 84.39 | 90.39 | | 87.39 | 87.39 | 87.39 | 87.39 | 87.39 |
| AP | 0.261 | 0.266 | | .262 | .262 | .262 | .262 | .262 |
| AQ | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

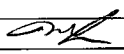
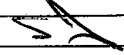
| | | | |
|------------------------------|------------|--------------|----------|
| Measured by: | <i>cmk</i> | Date: | 14/01/19 |
| Audited by: | <i>SL</i> | Date: | 14-1-23 |
| Preliminary Approval: | | Date: | 14/ |

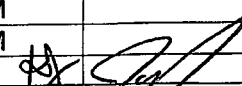
| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------|------------|--------------------|
| A | 02.12.13 | New Issue | KJ/RF | |
| B | 07.05.08 | Dimension AP revised | KJ/JLM | |
| C | 08.04.21 | Reformat | KJ/JLM | |
| D | 12.07.31 | Dwg Rev updated | KJ | <i>[Signature]</i> |

| | | | |
|------------------------------------|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 111 369 |
| Description: Ø2.750 Support | | Part Number: | D2893-1 |
| Inspection Dwg: D2893 | Rev: C | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 16 | 17 | 18 | 19 | 20 |
| HAAS Section | | | | | | | | |
| AA | 2.985 | 3.005 | | 2.995 | 2.995 | 2.995 | 2.995 | 2.995 |
| AB | 0.440 | 0.460 | | .440 | .440 | .440 | .440 | .440 |
| AC | 0.125 | 0.160 | | .127 | .128 | .128 | .128 | .128 |
| AD | 0.040 | 0.060 | | .050 | .050 | .050 | .050 | .050 |
| AE | 0.188 | 0.193 | | .189 | .189 | .189 | .189 | .189 |
| AF | 0.125 | 0.160 | | .140 | .140 | .140 | .140 | .140 |
| AG | 0.140 | 0.160 | | .150 | .150 | .147 | .151 | .151 |
| AH | 1.360 | 1.400 | | 1.374 | 1.374 | 1.372 | 1.374 | 1.374 |
| AI | 0.040 | 0.060 | | .053 | .0525 | .0521 | .0538 | .0521 |
| AJ | 1.190 | 1.230 | | 1.214 | 1.217 | 1.215 | 1.214 | 1.214 |
| AK | 0.010 | 0.020 | | .010 | .010 | .010 | .010 | .010 |
| AL | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AM | 0.240 | 0.260 | | .250 | .250 | .250 | .250 | .250 |
| AN | 2.518 | 2.538 | | 2.518 | 2.521 | 2.518 | 2.518 | 2.518 |
| AO | 84.39 | 90.39 | | 87.39 | 87.39 | 87.39 | 87.39 | 87.39 |
| AP | 0.261 | 0.266 | | .262 | .262 | .262 | .262 | .262 |
| AQ | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

| | | | |
|------------------------------|---|--------------|----------|
| Measured by: |  | Date: | 14/01/19 |
| Audited by: |  | Date: | 14-1-23 |
| Preliminary Approval: | | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------|------------|---|
| A | 02.12.13 | New Issue | KJ/RF | |
| B | 07.05.08 | Dimension AP revised | KJ/JLM | |
| C | 08.04.21 | Reformat | KJ/JLM | |
| D | 12.07.31 | Dwg Rev updated | KJ |  |

| | | | |
|------------------------------------|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 111369 |
| Description: Ø2.750 Support | | Part Number: | D2893-1 |
| Inspection Dwg: D2893 | Rev: C | Page 1 of 1 | |

FIRST ARTICLE INSPECTION DIMENSION SHEET

| | | | | Record Actual Dimensions | | | | |
|----------------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 11 | 12 | 13 | 14 | 15 |
| HAAS Section | | | | | | | | |
| AA | 2.985 | 3.005 | | 2.995 | 2.995 | 2.995 | 2.995 | 2.994 |
| AB | 0.440 | 0.460 | | .440 | .440 | 0.440 | 0.440 | 0.440 |
| AC | 0.125 | 0.160 | | .130 | .130 | 0.130 | 0.130 | 0.130 |
| AD | 0.040 | 0.060 | | .050 | .050 | 0.050 | 0.050 | 0.050 |
| AE | 0.188 | 0.193 | | .189 | .189 | 0.189 | 0.189 | 0.189 |
| AF | 0.125 | 0.160 | | 0.140 | .140 | 0.137 | 0.137 | 0.137 |
| AG | 0.140 | 0.160 | | 0.149 | 0.149 | 0.149 | 0.149 | 0.149 |
| AH | 1.360 | 1.400 | | 1.376 | 1.374 | 1.375 | 1.376 | 1.375 |
| AI | 0.040 | 0.060 | | .0538 | .0524 | 0.051 | 0.051 | 0.051 |
| AJ | 1.190 | 1.230 | | 1.218 | 1.218 | 1.218 | 1.217 | 1.218 |
| AK | 0.010 | 0.020 | | .010 | .010 | 0.010 | 0.010 | 0.010 |
| AL | 0.053 | 0.073 | | .063 | .063 | 0.063 | 0.063 | 0.063 |
| AM | 0.240 | 0.260 | | .250 | .250 | 0.250 | 0.250 | 0.250 |
| AN | 2.518 | 2.538 | | 2.528 | 2.528 | 2.528 | 2.528 | 2.528 |
| AO | 84.39 | 90.39 | | 87.39 | 87.39 | 87.39 | 87.39 | 87.39 |
| AP | 0.261 | 0.266 | | .262 | .262 | 0.262 | 0.262 | 0.262 |
| AQ | 0.053 | 0.073 | | .063 | .063 | 0.063 | 0.063 | 0.063 |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

| | | | |
|------------------------------|---|--------------|----------|
| Measured by: | <i>[Signature]</i> / <i>[Signature]</i> 08 9-8A | Date: | 14/01/20 |
| Audited by: | <i>[Signature]</i> | Date: | 14-1-23 |
| Preliminary Approval: | | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------|------------|--------------------|
| A | 02.12.13 | New Issue | KJ/RF | |
| B | 07.05.08 | Dimension AP revised | KJ/JLM | |
| C | 08.04.21 | Reformat | KJ/JLM | |
| D | 12.07.31 | Dwg Rev updated | KJ | <i>[Signature]</i> |

| | | | |
|------------------------------------|--|---------------------|--------------------|
| DART AEROSPACE LTD | | Work Order: | 111365 |
| Description: Ø2.750 Support | | Part Number: | D2893-1 |
| Inspection Dwg: D2893 | | Rev: C | Page 1 of 1 |

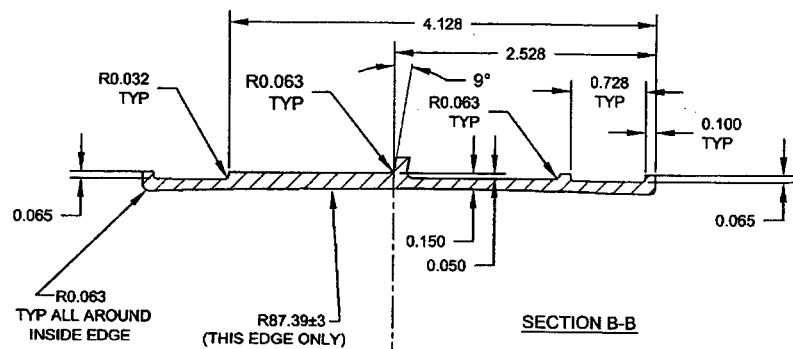
FIRST ARTICLE INSPECTION DIMENSION SHEET

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | #16 | #17 | #18 | #19 | #20 |
| HAAS Section | | | | | | | | |
| AA | 2.985 | 3.005 | | 2.994 | 2.994 | 2.995 | 2.995 | 2.994 |
| AB | 0.440 | 0.460 | | 0.440 | 0.440 | 0.440 | 0.440 | 0.440 |
| AC | 0.125 | 0.160 | | 0.130 | 0.130 | 0.130 | 0.130 | 0.130 |
| AD | 0.040 | 0.060 | | 0.050 | 0.050 | 0.050 | 0.050 | 0.050 |
| AE | 0.188 | 0.193 | | 0.189 | 0.189 | 0.189 | 0.189 | 0.189 |
| AF | 0.125 | 0.160 | | 0.137 | 0.137 | 0.137 | 0.137 | 0.137 |
| AG | 0.140 | 0.160 | | 0.147 | 0.148 | 0.149 | 0.148 | 0.147 |
| AH | 1.360 | 1.400 | | 1.376 | 1.375 | 1.377 | 1.377 | 1.377 |
| AI | 0.040 | 0.060 | | 0.049 | 0.051 | 0.051 | 0.051 | 0.052 |
| AJ | 1.190 | 1.230 | | 1.218 | 1.219 | 1.220 | 1.220 | 1.221 |
| AK | 0.010 | 0.020 | | 0.010 | 0.010 | 0.010 | 0.010 | 0.010 |
| AL | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | 0.063 |
| AM | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | 0.250 | 0.250 |
| AN | 2.518 | 2.538 | | 2.528 | 2.528 | 2.528 | 2.528 | 2.528 |
| AO | 84.39 | 90.39 | | 87.39 | 87.39 | 87.39 | 87.39 | 87.39 |
| AP | 0.261 | 0.266 | | 0.262 | 0.262 | 0.262 | 0.262 | 0.262 |
| AQ | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | 0.063 | 0.063 |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

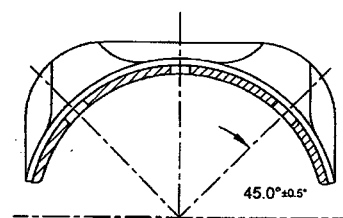
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|------------------------------|------|--------------|----------|
| Measured by: | B.A. | Date: | 14/01/21 |
| Audited by: | SA | Date: | 14-1-23 |
| Preliminary Approval: | | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------|------------|----------|
| A | 02.12.13 | New Issue | KJ/RF | |
| B | 07.05.08 | Dimension AP revised | KJ/JLM | |
| C | 08.04.21 | Reformat | KJ/JLM | |
| D | 12.07.31 | Dwg Rev updated | KJ | |

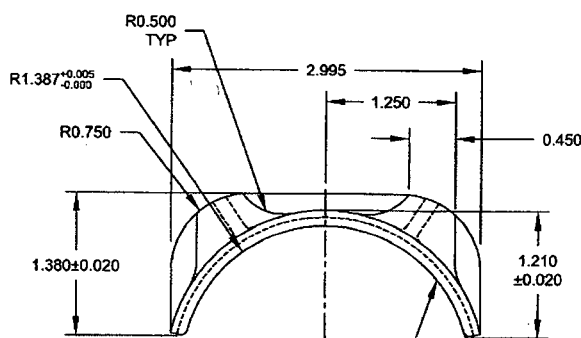
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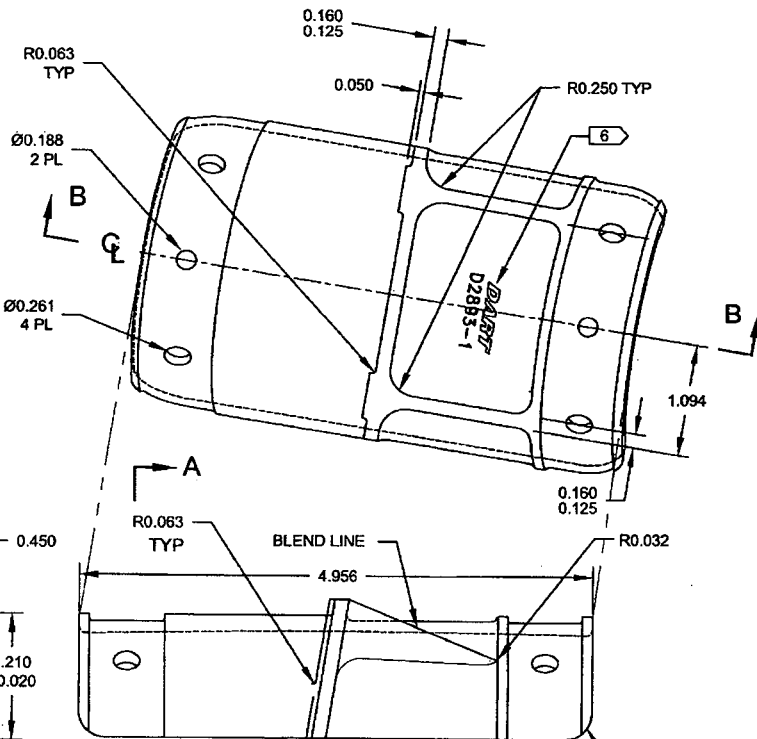
SECTION B-B



SECTION A-A
TOOLING HOLE DETAIL



D2893-1 SUPPORT



RELEASED
2011-07-28

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

| C | RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION | CP | 11.07.15 |
|------------|--|----|----------|
| B | UPDATE DIMS AS MFG, PRIME INSIDE | PH | 07.03.16 |
| A | NEW ISSUE | CP | 01.01.10 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | P | | |
| DRAWN | P | | |
| CHECKED | ASS | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 11.07.15 | | |

| | |
|--|------------------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D2893 | REV. C SHEET 1 OF 1 |
| TITLE Ø2.750 SUPPORT | SCALE NTS |
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